

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to provide instructions to replace the stainless steel NAS1330S3KB inserts used to attach the wearplates with cad-plated steel AELS-1032 inserts. Instructions are also provided for the removal of LPS-3 corrosion inhibitor.

PROCEDURE:

- 1) To remove LPS-3 from the interior of the skidtube, use LPS A-151 Cleaner/Degreaser per the manufacturer's instructions.
- 2) To replace NAS1330S3KB inserts with AELS-1032 inserts, perform the following:
 - (a) Remove the skidtube from the aircraft and disassemble the fwd / aft skidtube sections and wearplates per ICA-D412-742.
 - (b) Drill out the existing wearplate inserts.
 - (c) Counterbore indicated holes per Figures 1-3 and Table 1 of this service instruction using Ø7/16" c'bore bit with Ø1/4" c'bore pilot.
 - (d) Open holes with Ø19/64" drill bit (Ø0.297").
 - (e) Touch up holes with chemical film (Alodone 1200 or 1201) per MIL-C-5541.
 - (f) Install AELS-1032-XXX inserts per Figure 1-3 and Table 1 of this service instruction.
 - (g) Touch up paint finish with one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
 - (h) Reassemble and reinstall tube per ICA-D412-742.

The following replacement insert kits are available for the D412-742-011/-013 skidtubes:

QTY -041	QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X				DSI-9475-041	INSERT REPLACEMENT KIT
1	X			DSI-9475-011	INSERT REPLACEMENT KIT (D3391-011/-021 FWD TUBE)
1		X		DSI-9475-013	INSERT REPLACEMENT KIT (D3391-013/-023 MID TUBE)
1			X	DSI-9475-015	INSERT REPLACEMENT KIT (D3391-015/-025 AFT TUBE)
	2	20	14	AELS-1032-130	INSERT
	10		12	AELS-1032-225	INSERT

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REV.	DESCRIPTION	BY	DATE
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DRAWN	<i>92</i>	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9475	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INSERT REPLACEMENT	NTS
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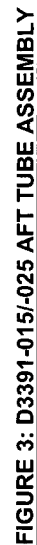
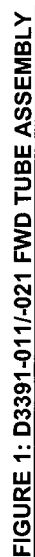


TABLE 1

HOLE	C'BORE dia. x depth	DRILL SIZE	INSERT
H1	N/A	Ø0.297"	AELS-1032-225
H2	Ø0.438"x0.040"	Ø0.297"	AELS-1032-130
H3	N/A	Ø0.297"	AELS-1032-130
H4	Ø0.438"x0.040"	Ø0.297"	AELS-1032-130
H5	Ø0.438"x0.170"	Ø0.297"	AELS-1032-225
H6	Ø0.438"x0.170"	Ø0.297"	AELS-1032-130
H7	N/A	Ø0.297"	AELS-1032-130

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MFG. APPR.	<i>[Signature]</i>	DSI 9475	SHEET 2 OF 2
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